

Date: Monday, 13/04/2009 8:22:36 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 350 SADDLE
<b>Job Number</b>	: 47119		
<b>Estimate Number</b>	: 12451		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D35001
<b>This Issue</b>	: 13/04/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3500 REV C
<b>First Issue</b>	: 1/1	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 46594	<b>Drawing Revision</b>	: C
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JUL 09.04.13</u>	<b>Due Date</b>	: 30/04/2009
<b>Comment</b>	: Est Rev:A New Issue 06-06-15 JLM	<b>Qty:</b>	12 <i>Paul</i>
		<b>Um:</b>	24 Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6102013	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)  
 6061-T6 7.0x6.5x2.0  
 350 Saddle Billet  
 Batch: 46414

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. SP Double check by: DIA

- 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
- 4-Debur
- 5-Tumble to remove sharp edges.

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEDIA 09/04/25

(12)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKSA 09/04/27

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 13/04/2009 8:22:36 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 47119

Part Number: D35001

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(X12)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UMD/FL

09/04/27

6.0

POWDER COATING

POWDER COATING



m109996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

13:05

OVEN TEMPERATURE:

320°

FINISH TIME:

13:35

UMD/FL

(X12)  
09/04/29

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT

FL

09/04/29

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 426

SS 09/04/30 X12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/30  
MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47119
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.381	.380	.380	.380		
F	0.490	0.510		.499	.500	.500	.500		
H									
I	R1.575	R1.595		1.592	1.590	1.591	1.591		
J	0.240	0.260		.245	.246	.245	.250		
K	0.490	0.510		.502	.500	.500	.500		
L	3.590	3.650		3.630	3.630	3.630	3.630		
M	0.315	0.322		.319	.322	.322	.321		
N	0.256	0.262		.259	.259	.289	.259		
O	6.500	6.520		6.513	6.500	6.500	6.500		
P	5.990	6.010		5.998	5.999	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.502	2.500	2.500	2.500		
S	2.245	2.255		2.252	2.252	2.250	2.250		
T	1.120	1.130		1.127	1.128	1.128	1.128		
U	0.540	0.560		.548	.553	.551	.552		
V	0.793	0.803		.800	.800	.800	.800		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.060	.06	.06		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.138	1.140	1.136	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.260	.260	.260	.250		
AE	1.810	1.830		1.825	1.823	1.823	1.817		
AF	0.240	0.260		.253	.258	.253	.258		
AG	0.140	0.160		.155	.158	.158	.158		
AH	0.140	0.160		.148	.148	.150	.150		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

<b>Measured by:</b> SP
<b>Date:</b> 09/04/24

<b>Audited by:</b> SD
<b>Date:</b> 09/04/24

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47119
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5x	6x	7x	8	By	Date
A	0.483	0.490		.485	.487	.487	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.380	.380	.380	0.373		
F	0.490	0.510		.500	.500	.500	0.500		
H									
I	R1.575	R1.595		1.591	1.580	1.5795	1.582		
J	0.240	0.260		.280	0.247	0.247	0.247		
K	0.490	0.510		.500	0.500	0.500	0.500		
L	3.590	3.650		3.630	3.630	3.630	3.630		
M	0.315	0.322		.321	.321	.321	0.321		
N	0.256	0.262		.257	.259	.259	0.259		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.127	1.127	1.127	1.127		
U	0.540	0.560		.552	0.550	0.550	0.550		
V	0.793	0.803		.800	.800	.800	.799		
W	R.240	R.260		.250	.250	.250	0.250		
X	0.040	0.060		.06	0.055	0.055	0.055		
Y	0.100	0.120		.100	0.100	0.100	0.100		
AA	R1.125	R1.145		1.138	1.1285	1.128	1.130		
AB	R.490	R.510		.500	0.500	0.500	0.500		
AC	0.615	0.635		.630	.630	.630	0.635		
AD	0.240	0.260		.250	0.257	0.256	0.2565		
AE	1.810	1.830		1.817	1.818	1.818	1.816		
AF	0.240	0.260		.2583	.251	.251	0.247		
AG	0.140	0.160		.150	.150	.150	0.149		
AH	0.140	0.160		.150	0.150	0.152	0.153		
AI	0.140	0.160		.150	0.150	0.152	0.154		
Accept/Reject									

Measured by: DP
Date: 09/04/24

Audited by: SA
Date: 09/10/24

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

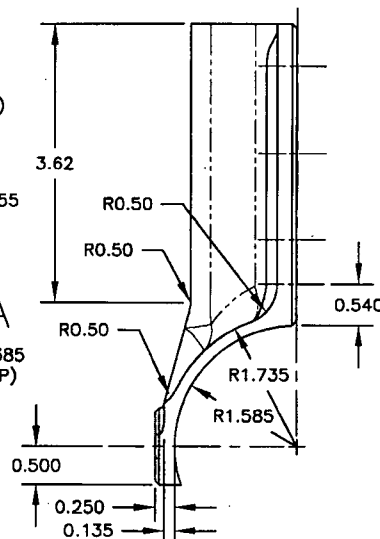
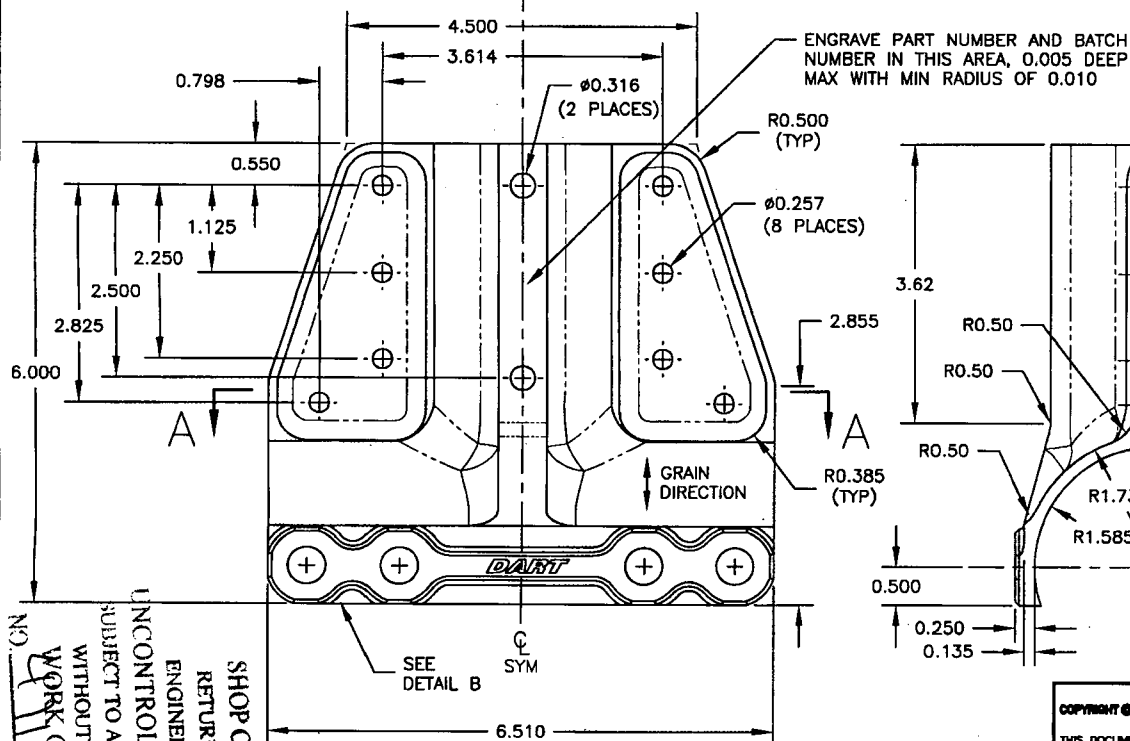
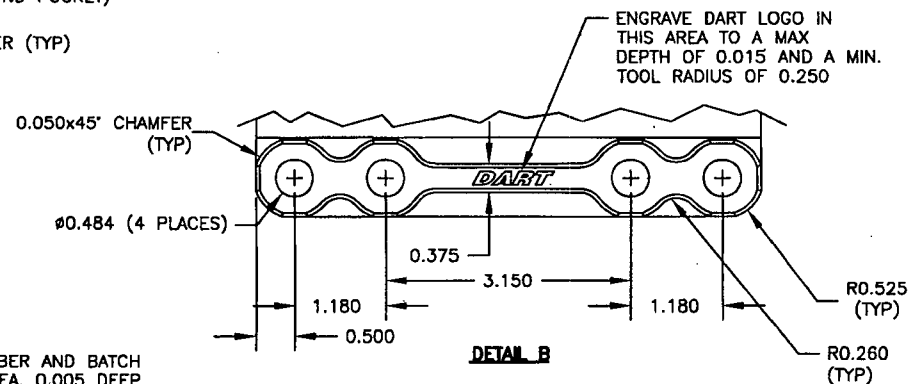
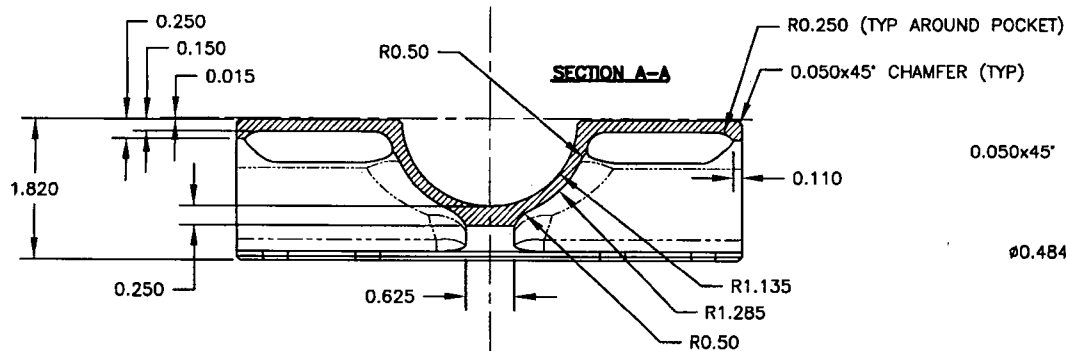
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47119
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.499		
H									
I	R1.575	R1.595		1.581	1.580	1.581	1.582		
J	0.240	0.260		0.247	0.246	0.246	0.246		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.630	3.630	3.63	3.63		
M	0.315	0.322		0.321	0.321	0.321	0.321		
N	0.256	0.262		0.259	0.259	0.259	0.259		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.127	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		0.799	0.799	0.799	0.799		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.129	1.128	1.130	1.131		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.257	0.257	0.257	0.255		
AE	1.810	1.830		1.816	1.816	1.816	1.816		
AF	0.240	0.260		0.245	0.248	0.248	0.245		
AG	0.140	0.160		0.1475	0.148	0.148	0.146		
AH	0.140	0.160		0.152	0.152	0.152	0.152		
AI	0.140	0.160		0.153	0.152	0.152	0.151		
Accept/Reject									

Measured by: JTA
Date: 09/04/25

Audited by: SD
Date: 08/10/27

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	



### D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

06-08-15

NO. *[Signature]*  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	<i>GP</i>	DRAWN BY <i>PH</i>
CHECKED	<i>[Signature]</i>	APPROVED <i>[Signature]</i>
DATE	06.06.30	TITLE
		SADDLE
		DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
		DRAWING NO. D3500
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3